

Wednesday, October 12, 2016 8:38:30 AM

Page 1

OCT 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 			
Description Work Order Deviation				Disposition							
								Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY							
Environment	☐		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong
Design	☐		Operator		Bending		Set-up		Folio/Program		Outside Dimensions
Doc/Data	☐		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Equip/Tooling	☐		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre	☐		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
Material	☐		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved
Internal Transport	☐		Poor Information		Crushing		Countersink		Off-set		Drawing
Tribal Knowledge	☐		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish
LOA	☐		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread
Substation	☐		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence
Past Expiry Date	☐		Manufacturing Process	OTHER :							
Misidentified	☐		Past Due								

Work Order ID 151843

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151843

Page 2

Item ID: D3219-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 10/12/2016 Start Qty: 140.00

140

Cust Item ID:

Required Date: 10/17/2016 Req'd Qty: 140.00

140

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.23

Packaging

*** STOCK IN STEP CELL ***
LOCATION : WA003cauty
144DAS
9-89
OCT 17 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

2.33

Quality Control

DAS
21
9-89

OCT 18 2016

DAS
21
9-89

OCT 17 2016

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OTHER :																									

Picklist Print

Wednesday, October 12, 2016 8:38:30 AM

Page 1

Work Order ID: 151843

151843

Parent Item: D3219-1

D3219-1

Parent Item Name: Plate

Start Date: 10/12/2016

Required Date: 10/17/2016

Start Qty: 140.00

Required Qty: 140.00

Comments: IPP A04.04.19New issueKJ/JLM
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	45.4300	0.0964	14.20632			

M6061T6S 125

6061-T6 .125 Sheet

R 10/10/15

Location

Loc Qty

Loc Code

MAT020

45.43

m134696

9.51

m134982

5.12

m135377

30.8

5.8

DQA: _____ Date: _____

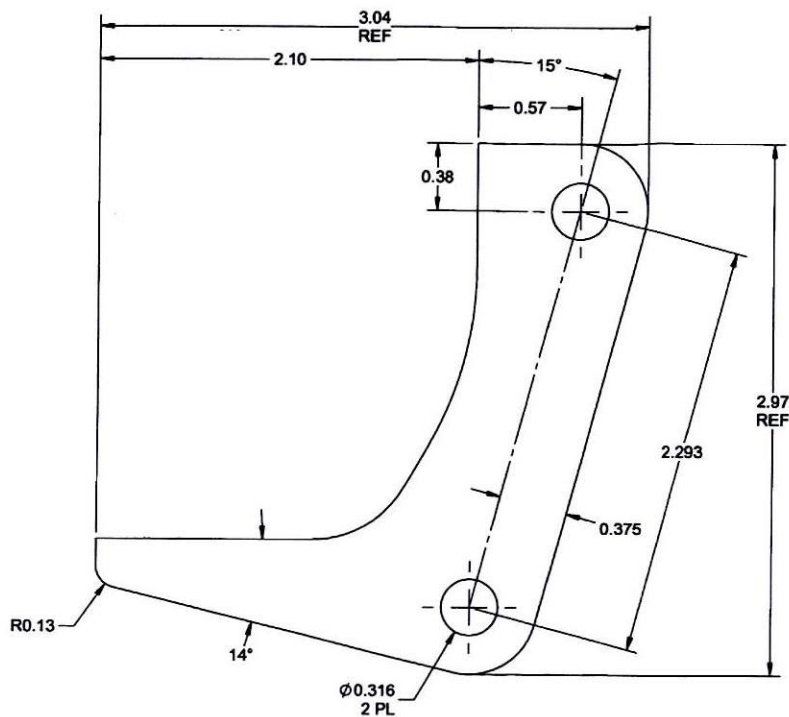
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		OTHER :																							



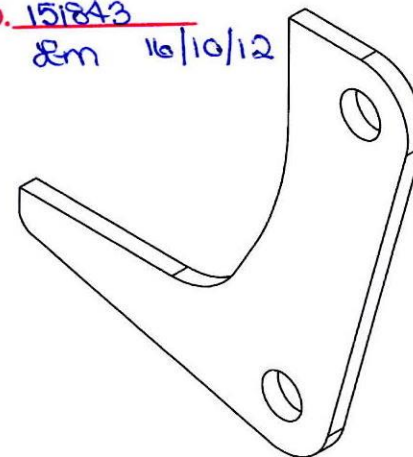
D3219-1 PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 151843

2m 16/10/12



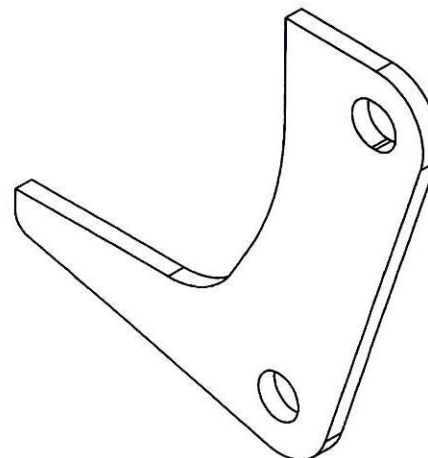
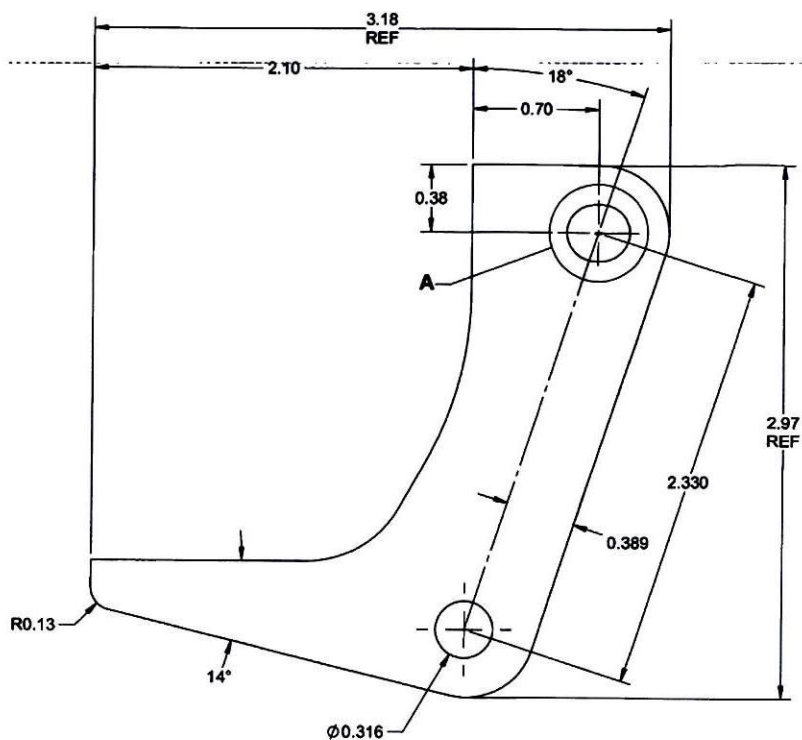
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- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125 THICK
PER: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE D3219-1-REV B.DXF

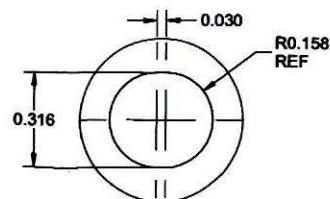
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2016-03-14
EON-656

APPROVED

B	REDRAWN TO CURRENT STANDARDS, ADD -3 & -5. REF CIR15-44.	AJS	15.11.27
A	NEW ISSUE	CP	03.10.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3219	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PLATE	NTS
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D3219-3 PLATE



DETAIL A
SCALE 2.5X

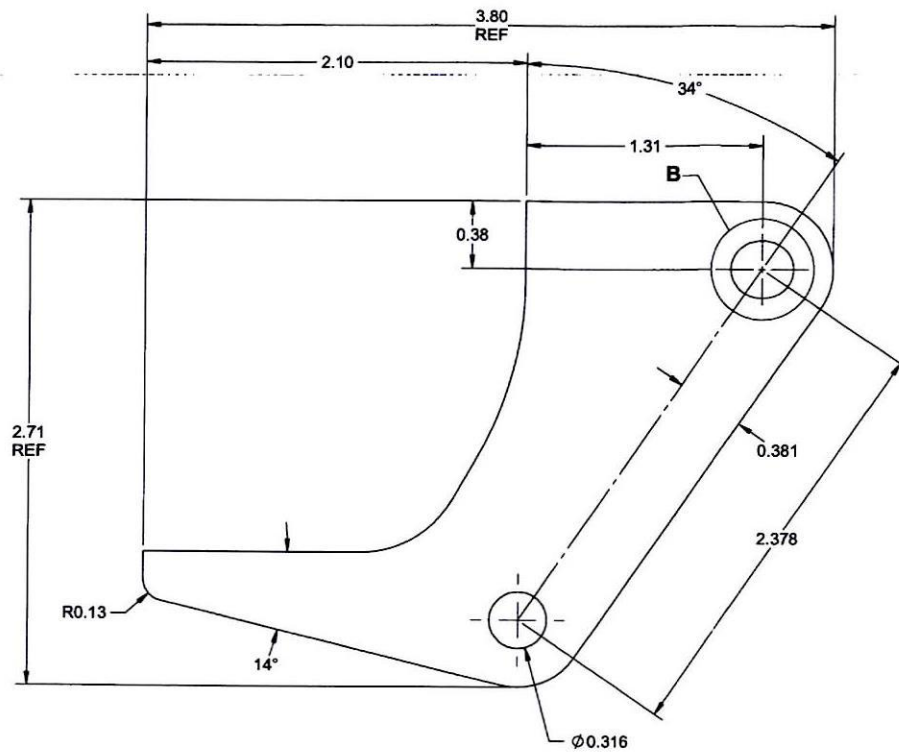
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125 THICK
PER: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE D3219-3-REV B.DXF

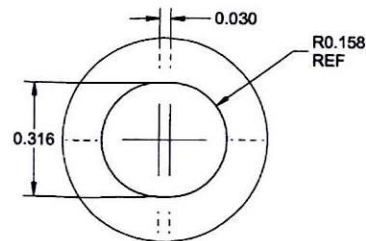
RELEASED
2016-03-14

APPROVED

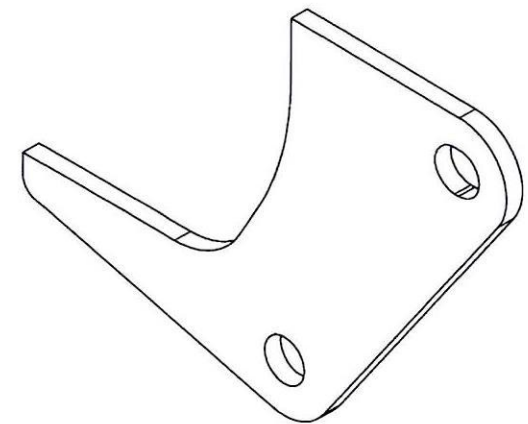
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DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3219	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	PLATE	NTS
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D3219-5 PLATE



DETAIL B
SCALE 2.5X



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125 THICK
PER: QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILE D3219-5-REV B.DXF

RELEASED
2016-03-14

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3219	SHEET 3 OF 3
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